

Date: Thursday, 5/10/2007 2:35:50 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	INNER AFT SADDLE
Job Number	32303	Part Number	D5957
Estimate Number	11082	Drawing Number	D5957 REV B
P.O. Number	N/A	Project Number	N/A
This Issue	5/10/2007	S.O. No.	N/A
Prsht Rev.	NC	Type	MACHINED PARTS
First Issue	N/A	Material	N/A
Previous Run	31531	Due Date	6/5/2007
Written By	14		
Checked & Approved By	Qty: 10 Um: Each		
Comment	Est Rev:E Re-Format 05-11-29 JLM	Est Rev:F	ecn826 06.12.06 ec

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101007	7075-T7351 8.25X7.75X2.5
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) D6101-007(7075-T7351) Size 2.50" x 7.50" X 8.25" (Grain along 7.50") Batch: 1325353		
2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
Comment: HAAS CNC VERTICAL MACHINING #3 1-Machine as per folio D5957, Ensure Batch Number is entered 2-Machine Keyway 3-Deburr & Tumble		
3.0	QC1	INSPECT ALL DIM TO DIM SHEET
Comment: INSPECT ALL DIM TO DIM SHEET		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/06/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:35:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER AFT SADDLE

Job Number: 32303

Part Number: D5957

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M104144



(14)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR/M-107-06-26

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



7/6/27 SP



(14)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/6/27 506

(14)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



(14)

Comment: FINAL INSPECTION/W/O RELEASE

4/30/06/07

Job Completion



U 07-06-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	32303
Description: Inner Aft Saddle				Part Number:	D5957
Inspection Dwg: D5957				Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		4.38	4.38	4.38	4.38		
B	1.745	1.755		1.751	1.751	1.750	1.751		
C	5.245	5.255		5.250	5.250	5.251	5.250		
D	6.995	7.005		7.000	7.001	7.001	7.000		
E	5.745	5.755		5.747	5.748	5.748	5.750		
F	4.745	4.755		4.748	4.748	4.749	4.750		
G	0.313	0.318		0.315 → 0.322	0.316	0.316	0.317		
H	1.522	1.532		1.525	1.525	1.525	1.526		
I	3.048	3.058		3.057	3.050	3.051	3.050		
J	4.575	4.585		4.581	4.580	4.581	4.580		
K	0.313	0.318		0.315 → 0.322	0.318	0.318	0.317		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.502	0.502	0.502	0.502		
N	1.865	1.885		1.877	1.876	1.877	1.877		
O	7.990	8.010		8.001	7.997	8.000	8.000		
P	2.240	2.260		2.250	2.250	2.251	2.250		
Q	0.307	0.312		0.310	0.310	0.310	0.311		
R	0.760	0.765		0.762	0.762	0.762	0.760		
S	0.490	0.510		0.495	0.495	0.495	0.495		
T	1.625	1.645		1.631	1.630	1.632	1.631		
U	2.000	2.020		2.008	2.008	2.008	2.008		
V	0.023	0.043		0.030	0.030	0.030	0.030		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	
Date:	07.06.21

Audited by:	
Date:	07.06.21

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	

DART AEROSPACE LTD				Work Order:	32303
Description: Inner Aft Saddle				Part Number:	D5957
Inspection Dwg: D5957				Rev: B	
				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		438	0.439	0.439	0.439		
B	1.745	1.755		1.750	1.748	1.748	1.749		
C	5.245	5.255		5.251	5.249	5.249	5.249		
D	6.995	7.005		7.000	6.999	6.999	6.999		
E	5.745	5.755		5.751	5.749	5.749	5.749		
F	4.745	4.755		4.750	4.749	4.749	4.749		
G	0.313	0.318	315 - 322	317	0.320	0.326	0.326		
H	1.522	1.532		1.527	1.525	1.525	1.525		
I	3.048	3.058		3.053	3.054	3.054	3.053		
J	4.575	4.585		4.579	4.579	4.579	4.579		
K	0.313	0.318	315 - 322	317	0.320	0.320	0.326		
L	0.495	0.505		500	500	500	500		
M	0.490	0.510		502	502	502	501		
N	1.865	1.885		1.877	1.877	1.877	1.881		
O	7.990	8.010		8.000	7.998	8.000	7.998		
P	2.240	2.260		2.245	2.251	2.256	2.256		
Q	0.307	0.312		0.310	0.316	0.310	0.316		
R	0.760	0.765		0.760	0.760	0.760	0.766		
S	0.490	0.510		498	503	503	504		
T	1.625	1.645		1.631	1.632	1.630	1.629		
U	2.000	2.020		2.000	2.000	2.000	2.000		
V	0.023	0.043		-030	0.33	0.033	0.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD / <i>one</i>	Audited by:	SG
Date:	07/06/23	Date:	07.06.23

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	

DART AEROSPACE LTD				Work Order:	32303
Description: Inner Aft Saddle				Part Number:	D5957
Inspection Dwg: D5957				Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.439	0.439	0.439	0.439		
B	1.745	1.755		1.749	1.749	1.749	1.749		
C	5.245	5.255		5.249	5.249	5.249	5.249		
D	6.995	7.005		6.999	6.999	6.999	6.999		
E	5.745	5.755		5.749	5.749	5.749	5.749		
F	4.745	4.755		4.749	4.749	4.749	4.749		
G	0.313	0.318	0.315 > 0.322	0.320	0.326	0.326	0.326		
H	1.522	1.532		1.525	1.525	1.525	1.525		
I	3.048	3.058		3.053	3.053	3.053	3.054		
J	4.575	4.585		4.579	4.579	4.579	4.579		
K	0.313	0.318	0.315 > 0.322	0.320	0.326	0.326	0.326		
L	0.495	0.505		0.506	0.500	0.500	0.499		
M	0.490	0.510		0.501	0.502	0.502	0.502		
N	1.865	1.885		1.882	1.882	1.881	1.881		
O	7.990	8.010		7.999	7.999	7.999	7.999		
P	2.240	2.260		2.256	2.256	2.256	2.256		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.505	0.505	0.505	0.505		
T	1.625	1.645		1.633	1.630	1.631	1.631		
U	2.000	2.020		2.000	2.000	2.000	2.000		
V	0.023	0.043		0.033	0.033	0.033	0.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>MD</i>	Audited by:	<i>SG</i>
Date:	07/06/23	Date:	07-06-23

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	

DART AEROSPACE LTD			Work Order:	32303
Description: Inner Aft Saddle			Part Number:	D5957
Inspection Dwg: D5957			Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

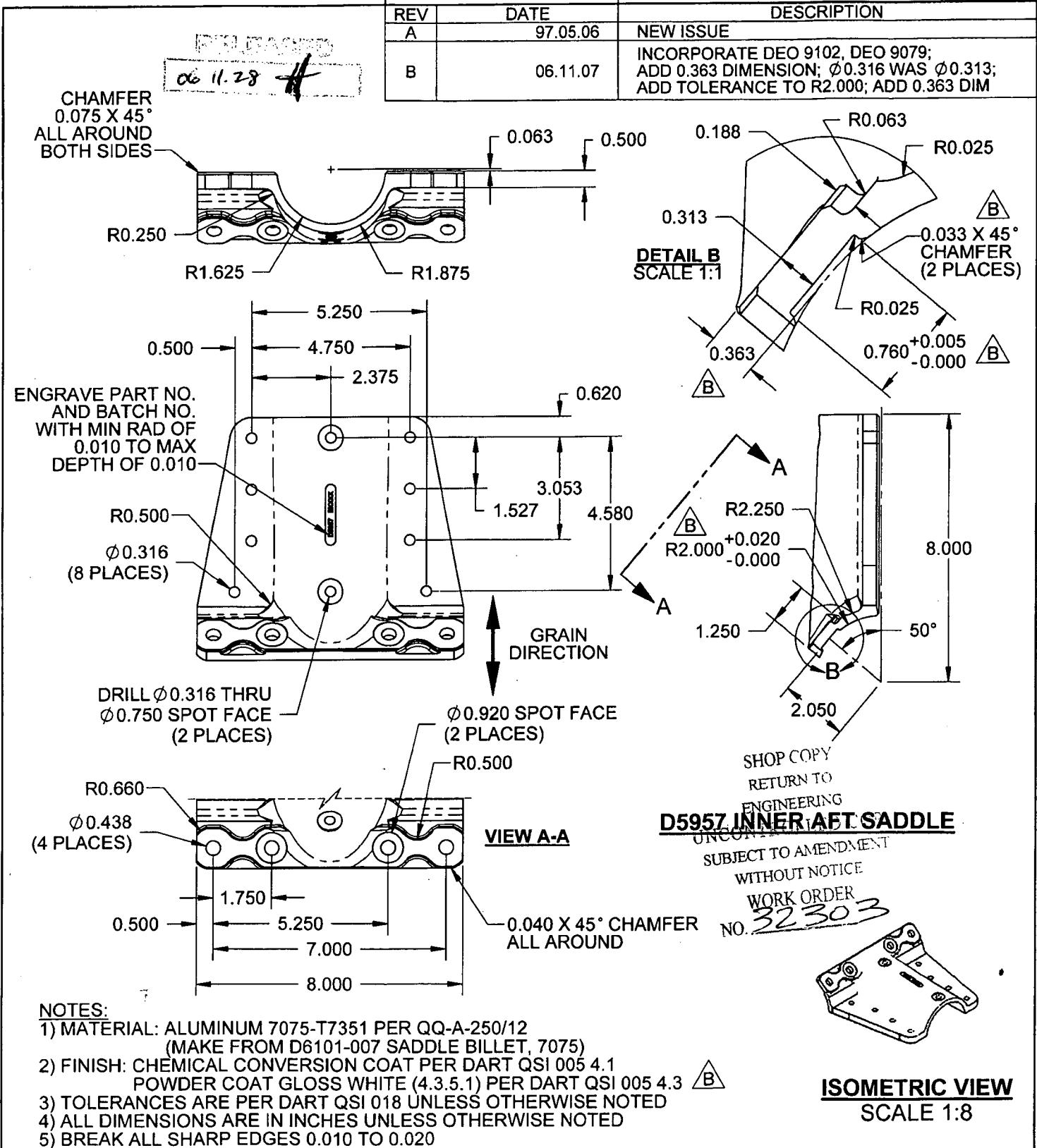
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.439	0.439				
B	1.745	1.755		1.749	1.748				
C	5.245	5.255		5.249	5.249				
D	6.995	7.005		7.000	7.006				
E	5.745	5.755		5.749	5.749				
F	4.745	4.755		4.749	4.749				
G	0.313	0.318	315-322	0.320	0.320				
H	1.522	1.532		1.525	1.525				
I	3.048	3.058		3.053	3.054				
J	4.575	4.585		4.579	4.579				
K	0.313	0.318	315-322	0.320	0.320				
L	0.495	0.505		0.494	0.506				
M	0.490	0.510		0.502	0.502				
N	1.865	1.885		1.882	1.882				
O	7.990	8.010		8.006	8.006				
P	2.240	2.260		2.256	2.257				
Q	0.307	0.312		0.310	0.310				
R	0.760	0.765		0.760	0.760				
S	0.490	0.510		0.502	0.504				
T	1.625	1.645		1.630	1.630				
U	2.000	2.020		2.000	2.006				
V	0.023	0.043		0.033	0.033				
W									
X									
Y									
Z									
AA									
A3									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>JML</i>	Audited by:	<i>JK</i>
Date:	07/06/23	Date:	07-06-23

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
E	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>TH</i>	DRAWING NO. D5957	REV. B SHEET 1 OF 1
DATE 06.11.07		TITLE INNER AFT SADDLE	SCALE 1:4
REV	DATE	DESCRIPTION	
A	97.05.06	NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; ϕ 0.316 WAS ϕ 0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020